

# Work Order ID 53527

November 09, 2009 8:34:34 AM



Page 1

Item ID: D209-669-043  
Revision ID: B  
Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 11/9/2009 Start Qty: 1.00  
Required Date: 11/20/2009 Req'd Qty: 1.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: mf Date: 09-11-09 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |                |              |              |               |               |                  |                |
| D2906                          | Rev B                    |                      |                |              |              |               |               |                  |                |

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D209-669 bluefile & type labels per PPP D205-669-043 Chg 002

N/A *[Signature]*

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2906 if necessary Debur ends

3-Acid etch and Alodine tube per QSI 005 4.1

)

1 11/9/11/11

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP

9-11-11

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

130

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Drill pilot holes using drill jig DT8149, DT8711-2 &amp; DT8711-3 (Do not use cutting fluid)

M 9/11/11

2-Open holes to 0.500" as per Dwg D2906 without cutting fluid

3-Countersink holes as per Dwg D2906 without cutting fluid

4-Deburr and blow out all chips from inside of tube

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting  
Pick:Qty ☐ Part Number ☐ Description ☐ Batch  
A/R ☐ Sikaflex-291 ☐ M112391 ☐

Sikaflex expire date: 2010/02/30

Start Time: 4 PM Date: 9-11-11

Fin Time: 8 AM Date: 9-11-12

pick:

| Qty | P/N     | description | B/N    |
|-----|---------|-------------|--------|
| 1   | D2926-3 | Web         | B53524 |

B53524

DP 9-11-11

DP 9-11-11

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: ☒ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Cust Item ID:

Required Date: 11/20/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description  | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 140<br>                        | BENDING MACHINE - CROSSTUBES  | 0.00                 |                |              |              |               |               |                  |                |
| CNC Bend 1                     | <b>Memo</b>   | 0.00                 |                |              |              |               |               |                  |                |
| CNC Delta 100 Bender           | 1-Bend as per program COB43FWD & COBRAFT on CNC Bender and Folio FT |                      |                |              |              |               |               |                  |                |
|                                | 2-Cut tubes as per Dwg. D2906 & per template DT8185B & DT8185BC     |                      |                |              |              |               |               |                  |                |
| 150<br>                        | Skidtubes   | 0.00                 |                |              |              |               |               |                  |                |
| Skidtubes                      | <b>Memo</b>   | 0.00                 |                |              |              |               |               |                  |                |
| Skidtubes                      | 1-Cut tube as per dwg and ensure ends are perpendicular to ridge    |                      |                |              |              |               |               |                  |                |
|                                | 2-Deburr ends   |                      |                |              |              |               |               |                  |                |
|                                | 3-Prepare tube for welding, remove alodine as required.             |                      |                |              |              |               |               |                  |                |
| 160<br>                        | QC5- Inspect part completeness to step on W/O                       | 0.00                 |                |              |              |               |               |                  |                |
| QC                             | <b>Memo</b>   | 0.00                 |                |              |              |               |               |                  |                |
| Quality Control                |   |                      |                |              |              |               |               |                  |                |

9-11-12

1 re 9/11/12

09/11/12

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

170

0.00



Large Fab

Skidtubes

Memo

0.00

Skidtubes

1-Weld crossbolt spacers D2579 as per Dwg. D2906 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

M112507

BE

09/11/12

2-Grind welds as per Dwg D2906 Grind flush ridge made from bending

DP 9-11-18

3-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

4-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2906, Deburr holes

5-Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Deburr

6-Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Deburr

180

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

2) 80211/19

④

1

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 53527**

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Item ID: D209-669-043

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID          | Operation<br>Description  | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 190<br><br>QC<br>Quality Control        | QC5- Inspect part completeness to step on W/O<br><br>Memo   | 0.00<br><br>0.00     | => 509/11/19   |              |              |               |               |                  |                |
| 200<br><br>HandFinish<br>Hand Finishing | Pressure Wash per QSI005 4.3<br><br>Memo  | 0.00<br><br>0.00     | => 10 08/11/19 |              |              |               |               |                  |                |
| 210<br><br>Powdercoat<br>Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum<br>M 112140<br>Memo<br>START TIME: 12:45<br>OVEN TEMPERATURE: 320°F<br>FINISH TIME: 1:15pm | 0.00<br><br>0.00     | all 09/11/19   |              |              |               |               |                  |                |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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Cust Item ID:

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220'

QC3- Inspect Part Finish

0.00

0.00  
BK 09-11-20

①.



QC

Memo

Quality Control

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☒ M112391

Sikaflex expire date: 10/20

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906

3-Inspect for foreign object per QSI 024

4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☒ M112391

Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2906 and QSI 005 4.4

Batch: M112623

BR 02-11-23 D.

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 53527

Parent Item: D209-669-043RevB

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 11/9/2009

Required Date: 11/20/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2500-1-190RevU/R               |                        | Manufactured  | No          |                     |                  | 110             | Each               | 0.0000         | 1.0000                   |               |                |        |
| Ext'n - I' Beam Tube 4"         |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |
| D2926-3RevA                     |                        | Manufactured  | No          |                     |                  | 110             | Each               | 1.0000         | 1.0000                   |               |                |        |
| Web                             |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

B53524

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

52066

1

1

170

Each

615.0000

19.0000

D2579RevE

Manufactured

No



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

51525

493

493

DP 9-11-11

Page 9

## Work Order ID 53527

November 09, 2009 8:34:34 AM

Item ID: D209-669-043

Revision ID: B

Item Name: Replacement Skidtube

Start Date: 11/9/2009 Start Qty: 1.00

Required Date: 11/20/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: Date: Tooling: Date: SPC (Y/N): Date:

| Sequence ID/<br>Work Center ID | Operation<br>Description  | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 240                            | QC5- Inspect part completeness to step on W/O   | 0.00                 |                |              |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |                |              |              |               |               |                  |                |
| Quality Control                | Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024 |                      |                |              |              |               |               |                  |                |
| 250                            | Packaging   | 0.00                 |                |              |              |               |               |                  |                |
| Packaging                      | Memo  | 0.00                 |                |              |              |               |               |                  |                |
| Packaging                      | Identify and pack for shipping as per PPPD209-669-043   |                      |                |              |              |               |               |                  |                |
|                                | Location: S7583 PPP   |                      |                |              |              |               |               |                  |                |
|                                | PPP Rev:  |                      |                |              |              |               |               |                  |                |
| 260                            | QC21- Final Inspection - Work Order Release   | 0.00                 |                |              |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |                |              |              |               |               |                  |                |
| Quality Control                |   |                      |                |              |              |               |               |                  |                |

Run

Start

Stop

Accept

Reject

Qty

Qty

Reject

Number

Insp.

Stamp

27809/11/23

10

12/9/14/25

09/11/26

pl 09/11-25

Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

NOTE: Date &amp; initial all entries

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Work Order ID: 53527

Parent Item: D209-669-043RevB

Parent Item Name: Replacement Skidtube


Start Date: 11/9/2009

Required Date: 11/20/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| AN960JD10L<br> |                        | Purchased     | No          |                     |                  | 230             | Each               | 5,719.000      | 4.0000                   |               |                |        |

Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

|          |      |
|----------|------|
| ST       | 5719 |
| 101291   | 16   |
| 104885   | 153  |
| 105793   | 236  |
| 109632 ✓ | 410  |
| 110985   | 4904 |

4 BL 09-11-23

\* ALS7-1032-130

Purchased

No

230

Each

1,880.000 44.0000



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

|           |      |
|-----------|------|
| ST 110511 | 1880 |
| 105855    | 16   |
| 108606    | 52   |
| 111529    | 1488 |
| 111779    | 313  |
| 112772    | 11   |

44. BL 09-11-23.

November 09, 2009 8:34:34 AM

Shop Packet Print

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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Work Order ID: 53527



Parent Item: D209-669-043RevB



Parent Item Name: Replacement Skidtube



Start Date: 11/9/2009

Required Date: 11/20/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick  | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|---------------|----------------|--------|
| AN3C4A<br> |                        | Purchased     | No          |                     |                  | 230             | Each               | 944.0000       | 44.0000   |               |                |        |
| BOLT   |                        |               |             |                     |                  |                 |                    |                |  |               |                |        |

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

|           |     |  |
|-----------|-----|--|
| ST 113121 | 944 |  |
| 112314    | 13  |  |
| 112720    | 12  |  |
| 112724    | 3   |  |
| 112794    | 316 |  |
| 112829    | 500 |  |
| 112991    | 100 |  |

44. BR 09-11-23.

AN960C10L

Purchased

No

230

Each

3,906.000

44.0000



washer

Warehouse                      Loc Qty                      Loc Code  
Location

OFFSHORE

|        |     |  |
|--------|-----|--|
| FG     | 100 |  |
| 103585 | 100 |  |

Main Warehouse

|          |      |  |
|----------|------|--|
| ST       | 3806 |  |
| 112116   | 628  |  |
| 112612 ✓ | 2178 |  |
| 112933   | 1000 |  |

44. BR 09-11-23.

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 53527



Parent Item: D209-669-043RevB



Parent Item Name: Replacement Skidtube


Start Date: 11/9/2009

Required Date: 11/20/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2594-3RevC<br><br>O-Ring, 205 Skidtube |                        | Manufactured  | No          |                     |                  | 230             | Each               | 994.0000       | 14.0000                  |               |                |        |

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

FP    27

51613    27

Main Warehouse

ST    967

52562 ✓                                      967

14. DK 09-11-23

D2594-1RevC

Manufactured No

230

Each

585.0000

14.0000



Plug, 205 Skidtube

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    585

42221    16

42807    92

43884    3

46435    2

51527    9

51757 ✓                                      463

14. DK 09-11-23

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



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Work Order ID: 53527



Parent Item: D209-669-043RevB



Parent Item Name: Replacement Skidtube


Start Date: 11/9/2009

Required Date: 11/20/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3564-9RevD<br><br>Wearshoe |                        | Manufactured  | No          |                     |                  | 230             | Each               | 31.0000        | 1.0000                   |               |                |        |



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

29

51675

7

52593 ✓

22

Main Warehouse

ST

2

44659

1

45825

1

*1 # 02-11-23*

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 53527



Parent Item: D209-669-043RevB



Parent Item Name: Replacement Skidtube

Start Date: 11/9/2009

Required Date: 11/20/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3564-11RevD                    |                        | Manufactured  | No          |                     |                  | 230             | Each               | 43.0000        | 1.0000                   |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

Wearshoe

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| FP               | 10             |                 |
| 51905            | 10             |                 |
| Main Warehouse   |                |                 |
| FP19             | 31             |                 |
| 51594 ✓          | 8              |                 |
| 52125            | 23             |                 |
| Main Warehouse   |                |                 |
| ST               | 2              |                 |
| 45823            | 1              |                 |
| 50112            | 1              |                 |

1 pl 09-11-23.

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 53527

Parent Item: D209-669-043RevB

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 11/9/2009

Required Date: 11/20/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3564-5RevD<br><br>Wearshoe |                        | Manufactured  | No          |                     |                  | 230             | Each               | 34.0000        | 1.0000                   |               |                |        |

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| OFFSHORE         |                |                 |
| FG               | 2              |                 |
| 34806            | 2              |                 |
| Main Warehouse   |                |                 |
| FP19             | 16             |                 |
| 51655            | 8              |                 |
| 51925            | 8              |                 |
| Main Warehouse   |                |                 |
| ST               | 16             |                 |
| 45824            | 1              |                 |
| 47433            | 1              |                 |
| 52595 ✓          | 14             |                 |

1 *pk* 09-11-23

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 53527



Parent Item: D209-669-043RevB



Parent Item Name: Replacement Skidtube

Start Date: 11/9/2009

Required Date: 11/20/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3566-1RevC                     |                        | Manufactured  | No          |                     |                  | 230             | Each               | 20.0000        | 2.0000                   |               |                |        |



Gasket



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| FP               | 15             |                 |
| 52512            | 15             |                 |
| Main Warehouse   |                |                 |
| ST               | 5              |                 |
| 46349            | 1              |                 |
| 51218            | 1              |                 |
| 51259            | 3              |                 |

**B455**

2 BR 09-11-23.

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

November 09, 2009 8:34:34 AM

Work Order ID: 53527



Parent Item: D209-669-043RevB



Parent Item Name: Replacement Skidtube

Start Date: 11/9/2009

Required Date: 11/20/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3566-5RevC                     |                        | Manufactured  | No          |                     |                  | 230             | Each               | 34.0000        | 1.0000                   |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

10

51929 ✓

10

Main Warehouse

FP19

20

52909

20

Main Warehouse

ST

4

36113

1

46186

1

47318

1

51260

1

*1 b109-11-23*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| QTY<br>-041 | QTY<br>-043 | Part Number   | Description                 |
|-------------|-------------|---|-----------------------------|
| X           |             | D2906-041   | SKIDTUBE ASSEMBLY           |
|             | X           | D2906-043   | SKIDTUBE ASSEMBLY           |
|             |             |   |                             |
| 1           | 1           | D2500-1-190   | EXTRUSION                   |
| 22          | 19          | D2579   | CROSS BOLT SPACER           |
| 12          | 14          | D2594-1   | PLUG                        |
| 12          | 14          | D2594-3   | O-RING                      |
| 2           | 2           | D2855   | AFT CAP                     |
| 1           |             | D2926-1   | WEB                         |
|             | 1           | D2926-3   | WEB                         |
| 1           | 1           | D3564-9   | WEARSHOE (REPLACES D2577-1) |
| 1           | 1           | D3564-11  | WEARSHOE (REPLACES D2577-3) |
| 1           | 1           | D3564-5   | WEARSHOE (REPLACES D2577-5) |
| 1           |             | D3564-15  | WEARSHOE                    |
| 2           | 2           | D3566-1   | GASKET                      |
| 1           | 1           | D3566-5   | GASKET                      |
| 1           |             | D3566-15  | GASKET                      |
|             |             |   |                             |
| 50          | 44          | ALS7-1032-130<br>or AKS7-1032-130<br>or AKS4-1032-130<br>or ALS4-1032-130 | INSERT                      |
| 50          | 44          | AN3C4A  | BOLT                        |
| 4           | 4           | AN3-5A  | BOLT                        |
| 50          | 44          | AN960C10L   | WASHER                      |
| 4           | 4           | AN960JD10L  | WASHER                      |

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

RELEASED

07.09.04

#535387

|            |  |  |              |
|------------|--|--|--------------|
| B          | UPDATE DRAWING FORMAT; RE-ORGANIZE;<br>ADD STAINLESS STEEL WEARPLATES AND GASKETS<br>CHANGE WEARPLATE HARDWARE TO SS;<br>PG 1: ADD NOTE 10;<br>PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041;<br>PG 3 C3: CORRECTED -043 CAP P/N;<br>PG 3 D7: 38 PLACES WAS 44 PLACES; | CB   | 07.08.21     |
| A          | NEW ISSUE  | CP   | 04.06.22     |
| REV.       | DESCRIPTION  | BY   | DATE         |
| DESIGN     | qp   | DART AEROSPACE LTD   |              |
| DRAWN      | CB   | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | PH   | DRAWING NO.  | REV. B       |
| MFG. APPR. | 21   | D2906  | SHEET 1 OF 3 |
| APPROVED   | 102  | TITLE  | SCALE        |
| DE APPR.   | 11   | AH-1 (209) SKIDTUBE ASSEMBLY   | NTS          |
| DATE       | 07.08.21   | COPYRIGHT © 2004 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

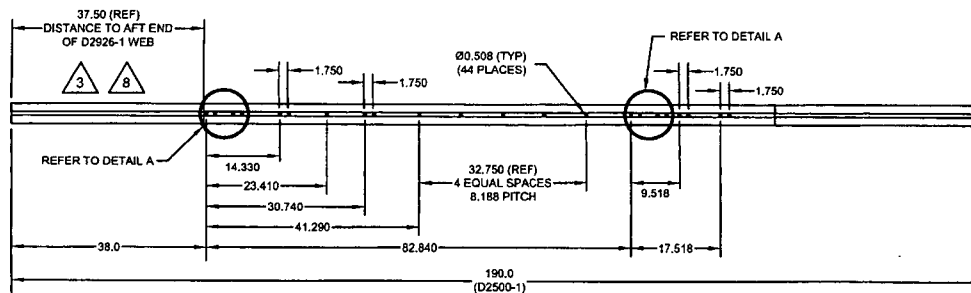
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

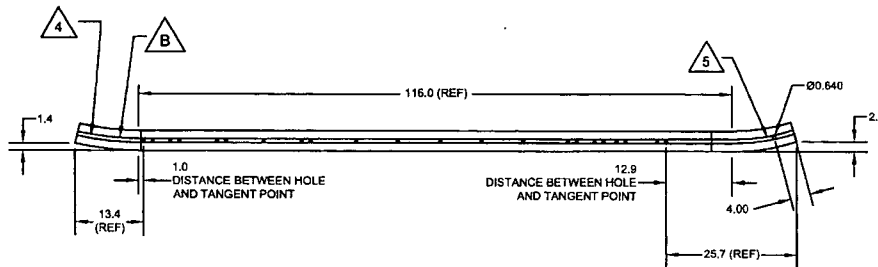
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

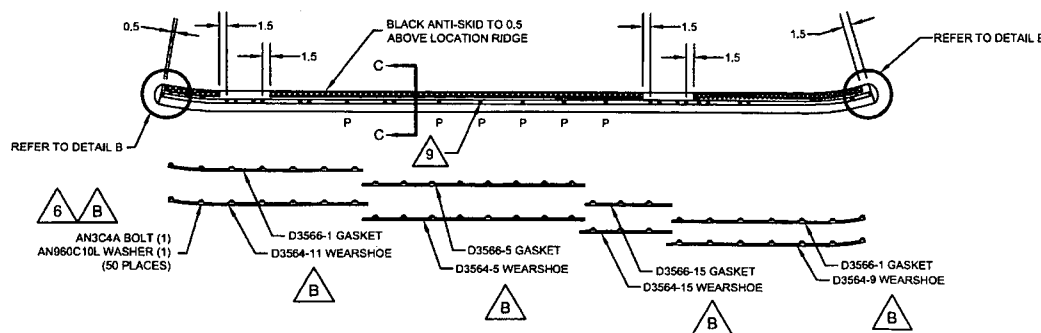
**NOTE:** Date & initial all entries



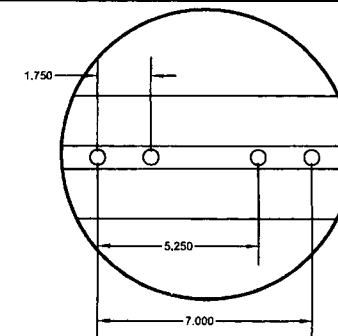
**D2906-1 DRILLING DETAIL**



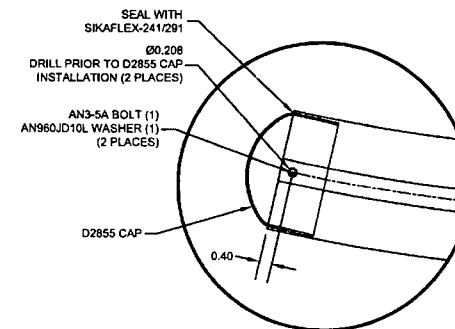
**D2906-041 BENDING AND CUTTING DETAIL**



**D2906-041 ASSEMBLY DETAIL**

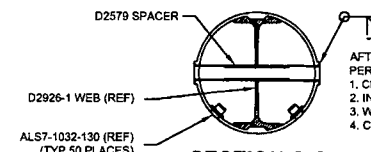


**DETAIL A  
SCALE 1:4**



**DETAIL B  
SCALE 1:4**

**RELEASED**  
07.09.04



**SECTION C-C  
SCALE 1:4**

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (22 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

|   |          |  |              |
|---|----------|--|--------------|
| DESIGN  | 90       | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN   | C.B.     | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED   | PH       | DRAWING NO.                            | REV. B       |
| MFG. APPR.  | PH       | D2906                                  | SHEET 2 OF 3 |
| APPROVED  | PH       | TITLE                                  | SCALE        |
| DE APPR.  | PH       | AH-1 (209) SKIDTUBE ASSEMBLY           | 1:24         |
| DATE  | 07.08.21 | COPYRIGHT © 2004 BY DART AEROSPACE LTD |              |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

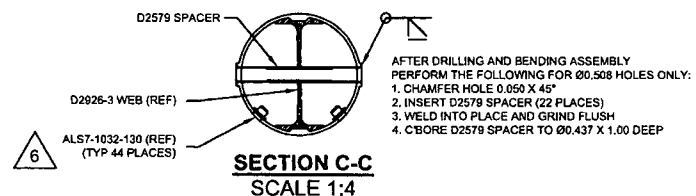
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



**RELEASED**

07.09.04



|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | Q        | <b>DART AEROSPACE LTD</b>   |              |
| DRAWN      | C.B.     | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    | PH       | DRAWING NO.   | REV. B       |
| MFG. APPR. | 21       | D2906   | SHEET 3 OF 3 |
| APPROVED   | 20       | TITLE   | SCALE        |
| DE APPR.   | 1        | AH-1 (209) SKIDTUBE ASSEMBLY  | 1:24         |
| DATE       | 07.08.21 | COPYRIGHT © 2004 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS RECOGNITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD |              |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



NO. 215

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 53175  
Part number: D205-634.041  
Description: 205 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[ ] DC[☒]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier [Signature] Date of Test Coupon 04.11.02

Welder [Signature] Date of Test Coupon 09.11.02

The above named individual is qualified in accordance with AWS D17.1.2001 to weld